

WHAT IS CLAIMED IS:

1. A measure method comprising the steps of:
 - A. forming a contrast image: a CPU (central processing unit) transforming an image from a lens set into a digital contrast image;
 - B. selecting a suitable standard line: the CPU selecting a suitable standard line from multiple standard lines that are previously set in the CPU in accordance with the measure need;
 - C. adjusting a worktable: an X-axis movement controller and a Y-axis movement controller being respectively adjusted to make the worktable being moved relative to an X-axis and a Y-axis of the worktable, the lens set continually collecting the image from the workpiece to make the contrast image moved relative to the selected standard line when the workpiece is moved due to a moving worktable;
 - D. flushing the standard line with the profile of the contrast image: the CPU detecting and changing the color of the selected standard line and flushed contrast image of the workpiece when the selected standard line flushes with a first side of the contrast image of the workpiece to make the operator clearly differentiate;
 - E. outputting the coordinate values of the X-axis and the Y-axis: the CPU reading the values from the linear scales of the X-axis and the Y-axis and sets the two linear scales to be zero when the selected standard line flushes with the first side of the contrast image of

the workpiece;

- F. contrasting the coordinate values of the X-axis and the Y-axis: repeating step D and E, the CPU reading the values from the linear scales of the X-axis and the Y-axis again when the selected 5 standard line flushes with a second side of the contrast image of the workpiece, and contrasts the values from the linear scales of the X-axis and the Y-axis in step D, wherein the first side and the second side of the contrast are opposite to each other; and

- G. outputting the measure value: the measure value 10 shown on a display panel and recorded in the CPU after the CPU contrasting the values from the linear scales of the X-axis and the Y-axis in step D and F.

2. The measure method as claimed in claim 1, wherein the digital contrast image and the selected standard line are shown on a 15 monitor such that the operator can clearly differentiate on the monitor.

3. The measure method comprising the steps of:
- A. forming a contrast image: a CPU (central processing unit) transforms an image from a lens set into a digital contrast image;
- B. selecting a suitable standard line: the CPU selecting a 20 suitable standard line from multiple standard lines that are previously set in the CPU in accordance with the measure need;

- C. adjusting the selected standard line: the selected standard line in the CPU being circularly moved relative to the contrast

image when operator adjusts the rotary controller;

- D. flushing the standard line with the profile of the contrast image: the CPU detecting and changing the color of the selected standard line and flushed contrast image of the workpiece
- 5 when the selected standard line flushes with a first side of the contrast image of the workpiece to make the operator clearly differentiate;

- E. outputting the rotary value of the selected standard line: the CPU reading the rotary value of the selected standard line and setting the rotary value to be zero when the selected standard line
- 10 flushes with the first side of the contrast image of the workpiece;

- F. contrasting the rotary value of the selected standard line: repeating step D and E, the CPU reading the rotary value of the selected standard line again when the selected standard line flushes with a second side of the contrast image of the workpiece, and
- 15 contrasts the rotary value in step D, wherein the first side and the second side of the workpiece form an angle; and

- G. outputting the measure value: the measure value being shown on a display panel and recorded in the CPU after the CPU contrasting the rotary values in step D and F.

- 20 4. The measure method as claimed in claim 3, wherein the digital contrast image and the selected standard line are shown on a monitor such that the operator can clearly differentiate on the monitor.

5. A length measure apparatus comprising:

- a base member;
 - a worktable moveably mounted on the base member;
 - an X-axis movement controller mounted to the worktable for controlling the movement of the worktable relative to the
- 5 X-axis of the worktable;
 - a Y-axis movement controller mounted to the worktable for controlling the movement of the worktable relative to the Y-axis of the worktable;
 - a lens set mounted to the measure apparatus and located
- 10 above the worktable for collecting the image of the workpiece that is put on the worktable;
 - a CPU (central processing unit) (CPU) in received in the base member and electrically connected to the lens set for executing a digital process to the image of the workpiece and forming a contrast
- 15 image, the CPU having multiple digital standard lines previously set therein;
 - a monitor mounted on the measure apparatus and electrically connected to the CPU, the monitor showing a corresponding one of the multiple standard lines of the CPU and the
- 20 contrast image of the workpiece, the monitor including a display panel for showing the measure result; and
 - a rotary controller mounted on the base member and electrically connected to the CPU, the rotary being provided to

circularly the standard lines relative to the contrast image.

6. The measure apparatus as claimed in claim 5, wherein the lens set is a CCD image collect module.

7. The measure apparatus as claimed in claim 5, wherein the
5 lens set is a CMOS image collect module.